

Work Order ID 83854

April-26-12 2:22:24 PM

\*83854\*

Page 1

Item ID: D3066-1

Accept

\*N900040100\*

Setup Start \*NS1\*

Revision ID:

Stop \*NS2\*

Item Name: Spacer

Start Date: 26/04/2012 Start Qty: 120.00

\*120\*

Cust Item ID:

Required Date: 03/05/2012 Req'd Qty: 120.00

\*120\*

Customer:

Reference:

Approvals:

Process Plan: MLJ

Date: 12/04/2012

Tooling:

Date:

Run Start \*NR1\*

QC:

Date:

SPC (Y/N):

Date:

Stop \*NR2\*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr

Revision Nbr

D3066

Rev B

100

0.00

\*100\*

FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D3066

6061.080

Dwg Rev: B

Prog Rev: B

2-Deburr if necessary

120 Ø Jm B12-5-2

110

0.00

\*110\*

QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

Quality Control

120 Ø Jm B12-5-2

120

0.00

\*120\*

QC8- Inspect parts - second check

QC

Memo

0.00

Quality Control

5.76 stop

(120) Ø

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

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\*120\*

Cust Item ID:

Required Date: 03/05/2012 Req'd Qty: 120.00

\*120\*

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start \*NR1\*

QC:

Date:

SPC (Y/N):

Date:

Stop \*NR2\*

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

130

Chemical Conversion Coat per QSI005 4.1

0.00

\*130\*

HandFinish

Memo

0.00

Hand Finishing

120 12-5-7

140

QC3- Inspect Part Finish

0.00

\*140\*

QC

Memo

0.00

Quality Control

120 12-5-7

150

Identify as per dwg &amp; Stock Location 87/H6 0.00

\*150\*

Packaging

Memo

0.00

Packaging

\*\*\* STOCK IN STEP CELL\*\*\*

120x 12-5-8

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Page 3

April-26-12 2:22:24 PM

Item ID: D3066-1 Accept \*N900040100\* Setup Start \*NS1\*  
 Revision ID: Stop \*NS2\*  
 Item Name: Spacer  
 Start Date: 26/04/2012 Start Qty: 120.00 \*120\* Cust Item ID:  
 Required Date: 03/05/2012 Req'd Qty: 120.00 \*120\* Customer:  
 Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_ Run Start \*NR1\*  
 QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop \*NR2\*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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160	QC21- Final Inspection - Work Order Release	0.00							
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\*160\*

QC	Memo	0.00							
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Quality Control

12/5/8 2J  
 MP  
 12-05-08

W/O:		WORK ORDER CHANGES					
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Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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**NOTE:** Date & initial all entries

# Picklist Print

April-26-12 2:22:28 PM

Page 1

Work Order ID: 83854

\*83854\*

Parent Item: D3066-1

\*D3066-1\*

Parent Item Name: Spacer

Start Date: 26/04/2012

Required Date: 03/05/2012

Start Qty: 120.00

Required Qty: 120.00

Comments: IPP: C02.11.01Incorporated D3066-1 IPPKJ/RF  
IPP Rev:B Now M6061-T6 06-06-23 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6S.080		Purchased			No			100	sf	556.2800	0.0945	11.93684	

\*M6061T6S 080\*

\*\*

6061-T6 .080 Sheet

Jm/B12-52

Location	Loc Qty	Loc Code
MAT021	556.28	
117285	2.15	
119766	39.6	
120096	311.13	
120349	11.4	
121193	192	

20349

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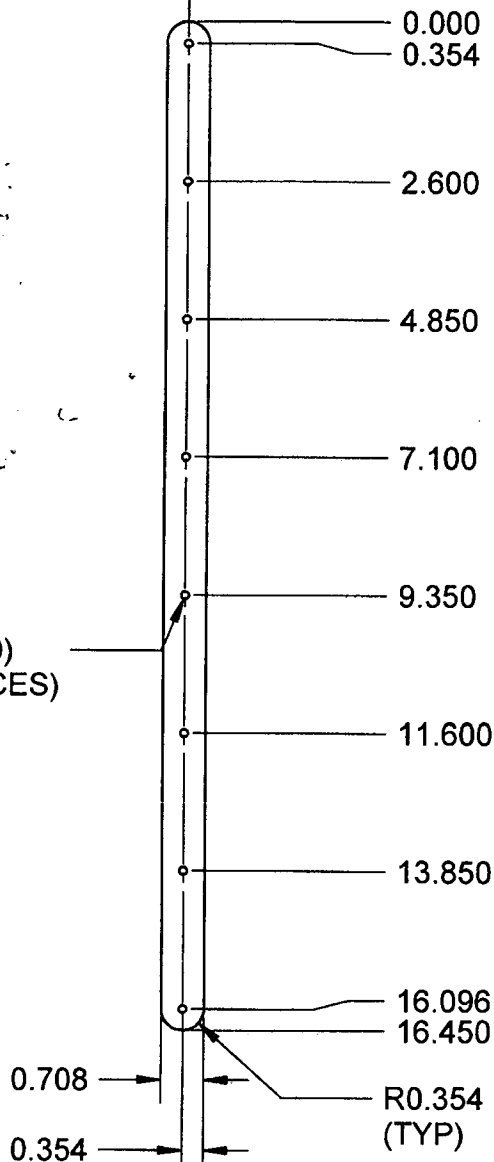
NOTE: Date & initial all entries



DESIGN <i>CP</i>	DRAWN BY <i>CB</i>	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>PH</i>	APPROVED <i>[Signature]</i>	DRAWING NO. <b>D3066</b>	REV. B SHEET 1 OF 1
DATE <b>06.05.29</b>		TITLE <b>SPACER</b>	SCALE 1:3
A	02.09.11	NEW ISSUE	
B	06.05.29	ADD 6061-T6 MATERIAL	

**RELEASED**  
*06.06.20* *[Signature]*

Ø 0.128 (#30)  
(TYP 8 PLACES)



SHOP COPY  
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INCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO 83857 M.C.J.  
12/04/26

**D3066-1 SPACER**

- 1) MATERIAL: 6061-T6 (PER QQ-A-250/11 OR AMS 4025 OR AMS 4027) 0.080" THICK (REF DART SPEC M6061T6S.080)  
OR  
5052-H32/H34 (PER QQ-A-250/8 OR AMS 4016) 0.080" THICK (REF DART SPEC. M5052H32S.080)
- 2) FINISH: ACID ETCH & ALODINE PER DART QSI 005 4.1
- 3) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 4) PART IS SYMMETRIC ABOUT CENTERLINE
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES

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